

Work Order ID 76954

\*76954\*

Page 1

Thursday, November 24, 2011 12:42:46 PM

Item ID: D350-636-012

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Skidtube RH

Start Date: 11/24/2011 Start Qty: 1.00

\*1\*

Cust Item ID:

Required Date: 12/1/2011 Req'd Qty: 1.00

\*1\*

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start \*NR1\*

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2750	F								
D3492	C								

100

0.00

\*100\*

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy blue file and type labels per PPP D350-636-012 CHG 006

5 w/12/28

11-12-28

①

76954.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

**Work Order ID 76954****\*76954\***

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**\*N900040100\***Setup Start **\*NS1\***

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Start Date: 11/24/2011 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 12/1/2011 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

110

0.00

**\*110\***

Skidtubes

0.00

Skidtubes

Memo

Skidtubes

1- Pick D2600-3 Bent

2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside AFT end per dwg D2750

3- Drill pilot holes for blade fitting bolt holes using DT8983. Open to 0.500", deburr.

4- Locate DT8329 off of blade fitting bolt holes and drill pilot holes for blade fitting

5- Drill only two fwd step holes using DT9616. Ensure proper positioning.

6- Drill pilot holes as per Dwg D2750 sheet 4 (D2750-2 details). Drill using drill Jig DT8150 &amp; DT8863A for first side only DT8863B for second side (detail K)

7- Clecko DT8863B on second side of tube and drill pilot holes for detail B.  
\*\*\*SECOND SIDE\*\*\*

8-Open up holes for Detail B to 0.375" (4 holes per side) and blade fitting location holes to 0.500" (total of 4 holes per side) as per dwg D2750. Open up holes for ground handling and detail L to 0.500" (8 holes per side)

9-Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to 0.297".

10-Open up holes of Detail A to 0.297" (total of 2 holes per side)

B 11/12/07

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

**\*76954\***

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**\*N900040100\***

Setup Start \*NS1\*

Stop \*NS2\*

**\* 1 \***

**Cust Item ID:**

**\* 1 \***

**Customer:**

**Reference:**

Run Start \*NR1\*

Stop **\*NR2\***

OC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

11-Weld D2744 Cap as per Dwg D2750 and QSI 004.Fill grooves in bend left from bending as per QSI 004  
A/R Aluminum Rod batch: *11118735* *BE11-12*

12-Grind welds flush as per Dwg D2750

0.00

0.00

120

**\*120\***

QC

## Quality Control

## Memo

130

**\*130\***

QC

## Quality Control

QC5- Inspect part completeness to step on W/O

0.00

0.00

## Memo

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Stop **\*NS2\***

Item Name: Skidtube RH

Start Date: 11/24/2011 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 12/1/2011 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	Chemical Conversion Coat per QSI005 4.1	0.00							
<b>*140*</b>									
HandFinish	Memo	0.00							
Hand Finishing									
150	QC3- Inspect Part Finish	0.00							
<b>*150*</b>									
QC	Memo	0.00							
Quality Control									

11-12-07  
11/12/07

DP

11-12-8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Item Name: Skidtube RH

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Cust Item ID:

Required Date: 12/1/2011 Req'd Qty: 1.00

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Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160		0.00							
<b>*160*</b>	Skidtubes	0.00							
Skidtubes	<b>Memo</b>								
Skidtubes	1-Open up holes of Detail L and ground handling to 0.625" (total of 8 holes per side) as per dwg D2750.								
	2-Open up holes of Detail K to 0.750" (total of 4 holes per side) as per dwg D2750.								
	3-Open float holes to .500" (4 per Side)								
	4-Chamfer holes of Detail K, L, ground handling and float holes per dwg D2750 (welding instructions on sheet 9)								
	5-Deburr and blow out all chips from inside of tube								
	6-Prepare tube for welding, remove alodine as required.								
	7-Bond web D2739 in place as per QSI 015 A/R Sikaflex-291 batch: <u>119399</u> exp. date: <u>12-8-13</u>								
	8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & QSI004 (welding instructions on sheet 9) A/R Aluminum Rod batch: <u>M118 735</u>								
	9- At section AP-AP drill out x-bolt spacer to 0.404"								
	10-Grind welds flush as per Dwg D2750								
	11-Spot face ground handling holes section (total of 4 places per side) as per								



11-12-8

7 BE 11-12-12

11-12-14

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Start Date: 11/24/2011 Start Qty: 1.00

\*1\*

Cust Item ID:

Required Date: 12/1/2011 Req'd Qty: 1.00

\*1\*

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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dwg D2750

12-Deburr holes

*Handwritten: 11-12-14*

170

QC10- Inspect visual per QSI004- ground welds

0.00

\*170\*

0.00

*Handwritten: 8/11/16*

QC

Memo

Quality Control

180

QC5- Inspect part completeness to step on W/O

0.00

\*180\*

0.00

*Handwritten: 8/11/16*

QC

Memo

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Revision ID:

Stop **\*NS2\***

Item Name: Skidtube RH

Start Date: 11/24/2011 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 12/1/2011 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	Pressure Wash per QSI005 4.3	0.00							
<b>*190*</b>									
HandFinish	Memo	0.00							
Hand Finishing	Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.								
200	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
<b>*200*</b>									
Powdercoat	Memo	0.00							
Powder Coating	START TIME: 12:00 OVEN TEMPERATURE: 320°F FINISH TIME: 12:30								
210	QC3- Inspect Part Finish	0.00							
<b>*210*</b>									
QC	Memo	0.00							
Quality Control	Inspect for foreign object per QSI 024								

① *ef/m* 11-22-16*IXP m* 11/12/19*m119-180**I* BR 11-12-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Revision ID:

Stop **\*NS2\***

Item Name: Skidtube RH

Start Date: 11/24/2011 Start Qty: 1.00

**\*1\***

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**\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
230	HandFinishing	0.00							
<b>*230*</b>									
HandFinish	<b>Memo</b>	0.00							
Hand Finishing	1-Install inserts as per dwg D2750								
	2-Inspect for Foreign Objects								
	3-Spray inside of tube with "LPS-3" batch: <u>N/A</u>								
	4-Install blade fitting D3488-042, wearshoes and ground handling hardware as per dwg D2750 SIKA FLEX 241 BATCH: <u>119543.</u> EXP DATE: <u>12-1.</u>								
	5-assemble o-ring to plug as per dwg D3492 and apply o-ring lube A/R 55-o-ring lube batch: <u>110348</u>								
	6-Coat all exposed fasteners with "LPS Procyon" batch: <u>114590.</u>								

1 162 11-12-22

W/O:		WORK ORDER CHANGES					
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**\*76954\***

Thursday, November 24, 2011 12:42:46 PM

**\*N900040100\***

Stop \*NS2\*

**\* 1 \***

**\* 1 \***

**Reference:**

Run Start \*NR1\*

Stop \*NR2\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

240

QC5- Inspect part completeness to step on W/O

0.00

**\*240\***

0.00

QC

## Memo

## Quality Control

250

## Pick Kit

0.00

**\*250\***

0.00

### Packaging

## Memo

## Packaging

260

QC4- 100% Inspect kits for completeness

0.00

**\*260\***

0.00

QC

## Memo

## Quality Control

W/O:		WORK ORDER CHANGES					
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Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

270

0.00

**\*270\***

Packaging

Packaging

Memo

0.00

Package as per PPP D350-636-012

Rev I  
Loc 78

11/12/2011

280

0.00

**\*280\***

QC21- Final Inspection - Work Order Release

QC

Memo

0.00

Quality Control

11/12/2011

11/12/2011

W/O:		WORK ORDER CHANGES					
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# Picklist Print

Thursday, November 24, 2011 12:42:50 PM

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Work Order ID: 76954

**\*76954\***

Parent Item: D350-636-012

**\*D350-636-012\***

Parent Item Name: Skidtube RH

Start Date: 11/24/2011

Required Date: 12/1/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev: I02.09.25 Rearranged procedure steps KJ  
 IPP Rev: J 06-03-29 As per Rev D EC  
 IPP Rev: K 06-07.13 As per dsi9343 EC  
 IPP Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM Verified By: EC  
 IPP Rev: M 08-04-22 update steps 4, 13 DD verified by: EC  
 IPP Rev: N 08-09-23 revF as per dwg DD verified by: ec IPP Rev: O  
 10.06.22 revise seq 110 DD verf: EC IPP Rev: P 10.10.01 as  
 per IIN revH DD verf: EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

ALS4-1032-225

Purchased

No

Each

1,885.000

38

**\*AI S4-1032-225\***

\*\*

Insert

Location

Loc Qty

Loc Code

ST281

1885

108696

281

110768

62

118386 ✓

858

118966 ✓

684

5  
38.

AN3C5A

Purchased

No

230

Each

797.0000

34

34

**\*AN3C5A\***

\*\*

Bolt

Location

Loc Qty

Loc Code

FP

7

115835

7

ST350

790

116419

28

117343

17

117764

52

117872

2

118451

191

119127

500

34.

BR 11-12-22

BR 11-12-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Parent Item: D350-636-012

**\*D350-636-012\***

Parent Item Name: Skidtube RH

Start Date: 11/24/2011

Required Date: 12/1/2011

Start Qty: 1.00

Required Qty: 1.00

AN3C6A

Purchased

No

230

Each

252.0000

4

4

**\*AN3C6A\***

\*\*

BR 11-12-22.

BOLT

LocationLoc QtyLoc Code

FP

119749

1

4.

111982

1

ST350

100

119449

100

ST351

151

111982

2

116419

23

116549

2

116704

12

117619

10

117688

1

117872

5

118422

96

AN6C44A

Purchased

No

230

Each

107.0000

4

4

**\*AN6C44A\***

\*\*

BR 11-12-22.

BOLT

LocationLoc QtyLoc Code

FG

2

103964

2

ST343

105

118985

40

119125

30

119530

35

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

Thursday, November 24, 2011 12:42:50 PM

Work Order ID: 76954

**\*76954\***

Parent Item: D350-636-012

**\*D350-636-012\***

Parent Item Name: Skidtube RH

Start Date: 11/24/2011

Required Date: 12/1/2011

Start Qty: 1.00

Required Qty: 1.00

AN8C35A

Purchased

No

230

Each

99.0000

1

1

**\*AN8C35A\***

BOLT

\*\*

BR 11-12-22

Location

Loc Qty

Loc Code

FP

65

115960

1

118286

64

ST345

33

117834 ✓

33

ST346

1

114442

0


115188

0

115960

1

AN960C10L

 NAS1149C0332 /

Purchased

No

230

Each

0.0000

38

38

**\*AN960C10I \***

washer

D2745

Manufactured

No

230

Each

133.0000

8

8

**\*D2745\***

Bushing

\*\*

38

BR 11-12-22

\*\*

BR 11-12-22

Location

Loc Qty

Loc Code

FP

73

69529

1

74446 ✓

72

ST021

60

71835

60

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Thursday, November 24, 2011 12:42:50 PM

Work Order ID: 76954

**\*76954\***

Parent Item: D350-636-012

**\*D350-636-012\***

Parent Item Name: Skidtube RH

Start Date: 11/24/2011

Required Date: 12/1/2011

Start Qty: 1.00

Required Qty: 1.00

D3488-042

Manufactured No

230

Each

23.0000

1

1

**\*D3488-042\***

Blade Fitting Assembly, RH

\*\*

BR 11-12-22

Location

Loc Qty

Loc Code

FP002

11

75068

11

FP008

12

62003

1

69904 ✓

2

71883

9

D3492-1

Manufactured No

230

Each

46.0000

8

8

**\*D3492-1\***

Plug

\*\*

BR 11-12-22

\*D3492 041.

Location

Loc Qty

Loc Code

FP

46

69531

8

74444

38

D3492-3

Manufactured No

230

Each

89.0000

8

8

**\*D3492-3\***

Plug

\*\*

BR 11-12-22

Location

Loc Qty

Loc Code

FP

45

74447

45

FP-B

44

74871 ✓

44

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Thursday, November 24, 2011 12:42:51 PM

Work Order ID: 76954

**\*76954\***

Parent Item: D350-636-012

**\*D350-636-012\***

Parent Item Name: Skidtube RH

Start Date: 11/24/2011

Required Date: 12/1/2011

Start Qty: 1.00

Required Qty: 1.00

D3535-25

Manufactured No

230

Each

28.0000

1

1

**\*D3535-25\***

Wearshoe

\*\*

BR 11-12-22

Location

Loc Qty

Loc Code

FP001

18

74525

6

75040

12

FP018

10

62233

1

74592 ✓

9

D3536-25

Manufactured No

230

Each

31.0000

1

1

**\*D3536-25\***

Gasket

\*\*

BR 11-12-22

Location

Loc Qty

Loc Code

FP012

31

74595

5

75039 ✓

26

D3537-1

Manufactured No

230

Each

42.0000

3

3

**\*D3537-1\***

Wearpad

\*\*

BR 11-12-22

Location

Loc Qty

Loc Code

FP002

35

74436

30

74597

5

FP017

7

69817

5

70686

2

3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Thursday, November 24, 2011 12:42:51 PM

Work Order ID: 76954

**\*76954\***

Parent Item: D350-636-012

**\*D350-636-012\***

Parent Item Name: Skidtube RH

Start Date: 11/24/2011

Required Date: 12/1/2011

Start Qty: 1.00

Required Qty: 1.00

D3631-1

Manufactured No

230 Each

495.0000 8 8

**\*D3631-1\***

Washer

\*\*

*BR 11-12-22*

Location

Loc Qty

Loc Code

ST072

495

68062  
75548 ✓

10  
485

*8*

D3791-1

Manufactured No

230 Each

31.0000 1 1

**\*D3791-1\***

Wearplate

\*\*

*BR 11-12-22*

Location

Loc Qty

Loc Code

FP002

16

75041

16

FP017

15

62239  
74527  
74598 ✓

2  
1  
12

*1*

D3793-1

Manufactured No

230 Each

20.0000 1 1

**\*D3793-1\***

Wearshoe

\*\*

*BR 11-12-22*

Location

Loc Qty

Loc Code

FP001

12

~~74546~~  
75038 ✓

12

FP018

8

74591

8

*1*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

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Work Order ID: 76954

**\*76954\***

Parent Item: D350-636-012

**\*D350-636-012\***

Parent Item Name: Skidtube RH

Start Date: 11/24/2011

Required Date: 12/1/2011

Start Qty: 1.00

Required Qty: 1.00

D3793-3 Manufactured No

230 Each

24.0000

1 1

**\*D3793-3\***

Wearshoe

\*\*

BR 11-12-22

Location

Loc Qty

Loc Code

FP001

24

74528 ✓

8

74593

4

75043

12

D3794-1 Manufactured No

230 Each

41.0000

1 1

**\*D3794-1\***

Gasket

\*\*

BR 11-12-22

Location

Loc Qty

Loc Code

FP014

41

74529

1

74594 ✓

12

75042

28

D3794-3 Manufactured No

230 Each

23.0000

1 1

**\*D3794-3\***

Gasket

\*\*

BR 11-12-22

Location

Loc Qty

Loc Code

FP002

23

74530

9

74596 ✓

14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Work Order ID: 76954

**\*76954\***

Parent Item: D350-636-012

**\*D350-636-012\***

Parent Item Name: Skidtube RH

Start Date: 11/24/2011

Required Date: 12/1/2011

Start Qty: 1.00

Required Qty: 1.00

MS21043-6 Purchased No

230 Each

449.0000 4 4

**\*MS21043-6\***

NUT

\*\*

*BL 11-12-22*

Location	Loc Qty	Loc Code
FG	20	
103693	20	
ST300	429	
112314 ✓	219	<i>H.</i>
117887	10	
118384	200	

MS21083C8 Purchased No

230 Each

100.0000 1 1

**\*MS21083C8\***

NUT

\*\*

*BL 11-12-22*

Location	Loc Qty	Loc Code
FP-B	1	
115884	1	
ST293	1	
118077	1	
ST303	98	
115884	0	
118614 ✓	37	<i>1</i>
119309	11	
119436	25	
119638	25	

NAS1149C0832R Purchased No

230 Each

331.0000 1 1

**\*NAS1149C0832R\***

WASHER

\*\*

*BL 11-12-22*

Location	Loc Qty	Loc Code
FP-B	3	
114915 ✓	3	<i>1</i>
ST297	328	
114915	328	

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID: 76954

**\*76954\***

Parent Item: D350-636-012

**\*D350-636-012\***

Parent Item Name: Skidtube RH

Start Date: 11/24/2011

Required Date: 12/1/2011

Start Qty: 1.00

Required Qty: 1.00

NAS1515H3L

Purchased

No

230

Each

155.0000

4

4

**\*NAS1515H3I \***

WASHER

\*\*

BR 11-12-22.

LocationLoc QtyLoc Code

FG

40

102472

40

ST277

115

113362

11

118686

4

119438 ✓

100

4.

NAS1611-010

Purchased

No.

230

Each

235.0000

8

8

**\*NAS1611-010\***

O-RING

\*\*

BR 11-12-22.

LocationLoc QtyLoc Code

FP

235

110915

14

117460

8

118077

1

118612

3

119438

159

119623 ✓

50

4

NAS1611-013

Purchased

No

230

Each

196.0000

8

8

**\*NAS1611-013\***

O-RING

\*\*

BR 11-12-22.

LocationLoc QtyLoc Code

FP

196

116582

5

117291

2

117887

53

119307

76

119438 ✓

10

119623 ✓

50

8.1

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Work Order ID: 76954

\*76954\*

Parent Item: D350-636-012

\*D350-636-012\*

Parent Item Name: Skidtube RH

Start Date: 11/24/2011

Required Date: 12/1/2011

Start Qty: 1.00

Required Qty: 1.00

AN8C21A

Purchased No

250 Each

71.0000

2

2

\*AN8C21A\*

BOLT

\*\*

Location

Loc Qty

Loc Code

ST343

71

118045

11

118758

30

119530

30

D2741

Manufactured No

250

Each

3.0000

1

1

\*D2741\*

Blade, 350 Skidtube

\*\*

Location

Loc Qty

Loc Code

ST466

3

70667

3

D3493-1

Manufactured No

250

Each

61.0000

2

2

\*D3493-1\*

Washer

\*\*

Location

Loc Qty

Loc Code

ST062

61

70697

4

71846

27

76237

30

D3532-1

Manufactured No

250

Each

46.0000

2

2

\*D3532-1\*

Spacer

\*\*

Location

Loc Qty

Loc Code

ST065

46

73342

6

74880

40

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

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Thursday, November 24, 2011 12:42:51 PM

Work Order ID: 76954

**\*76954\***

Parent Item: D350-636-012

**\*D350-636-012\***

Parent Item Name: Skidtube RH

Start Date: 11/24/2011

Required Date: 12/1/2011

Start Qty: 1.00

Required Qty: 1.00

MS21083C8

Purchased

No

250

Each

100.0000

2

2

**\*MS21083C8\***

NUT

\*\*

Location

Loc Qty

Loc Code

FP-B

1

115884

1

ST293

1

118077

1

ST303

98

115884

0

118614

37

119309

11

119436

25

119638

25

NAS1149D0863J

Purchased

No

250

Each

208.0000

2

**\*NAS1149D0863J\***

WASHER

\*\*

Location

Loc Qty

Loc Code

ST298

208

118078

108

119307

100

D2600-3-BENT

Manufactured

No

110

Each

22.0000

1

1

**\*D2600-3-BENT\***

Extrusion Bent

\*\*

Location

Loc Qty

Loc Code

LG

22

66875

8

73253

1

75021

4

75022

8

75023

1

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Thursday, November 24, 2011 12:42:51 PM

Work Order ID: 76954

**\*76954\***

Parent Item: D350-636-012

**\*D350-636-012\***

Parent Item Name: Skidtube RH

Start Date: 11/24/2011

Required Date: 12/1/2011

Start Qty: 1.00

Required Qty: 1.00

D2744

Manufactured No

110

Each

47.0000

1

1

**\*D2744\***

Cap

\*\*

BE 11-12-07

Location

Loc Qty

Loc Code

LG002

13

62715

1

70881

12

WA

34

71861

34

D2739

Manufactured No

160

Each

14.0000

1

1

**\*D2739\***

350 I Beam

\*\*

DP 11-12-8

Location

Loc Qty

Loc Code

LG

14

72155

1

76140

6

76866

4

76867

3

D2743

Manufactured No

160

Each

279.0000

8

8

**\*D2743\***

Crossbolt Spacer

\*\*

BE 11-12-12

Location

Loc Qty

Loc Code

LG

269

71839

5

73403

64

74445

100

76141

100

LG001

10

67766

4

68251

6

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Thursday, November 24, 2011 12:42:51 PM

Work Order ID: 76954

**\*76954\***

Parent Item: D350-636-012

**\*D350-636-012\***

Parent Item Name: Skidtube RH

Start Date: 11/24/2011

Required Date: 12/1/2011

Start Qty: 1.00

Required Qty: 1.00

D3490-3 Manufactured No

160 Each

74.0000

4

4

**\*D3490-3\***

Cross Bolt Spacer

**\*\***

*BE11-12-12*

Location

Loc Qty

Loc Code

LG

34

76234

34

LG001

40

74877

40

*4*

D3490-1 Manufactured No

160 Each

114.0000

4

4

**\*D3490-1\***

Cross Bolt Spacer

**\*\***

*BE11-12-12*

Location

Loc Qty

Loc Code

LG

8

67773

5

71841

3

LG001

106

62450

2

74875

64

76233

40

*4*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

# GENERAL NOTES:

- MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- FINISH:  
ACID ETCH, ALONDE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.  
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: N/A
- IDENTIFICATION: N/A
- WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- WELD PER DART QSI 004
- INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES ( $\phi 0.297$ ) FOR WEARSHOE INSERTS
- FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:  
MINIMUM YIELD TENSILE STRENGTH = 35 KSI  
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS.  
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY. CLEAN EXCESS OFF  
POWDER COATING WITH MEK DEGREASER.
- SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

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65 07 22 148

F	INCORPORATE DSI 9413; QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/3 REPLACES D3535-13/35 (ZN C8-1); D3794-1/3 REPLACES D3536-13/35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL). WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NCR 68-045	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS; CHANGE INSERTS; ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515H8L; REMOVE D2741, QTY (2) AN960C816; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEO 9133/9157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24694-S293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.07.16		
DART AEROSPACE USA, INC. PORT HADLOCK, WA			
DRAWING NO. D2750		REV. F SHEET 1 OF 11	
TITLE 350 SKIDTUBE ASSEMBLY		SCALE NTS	
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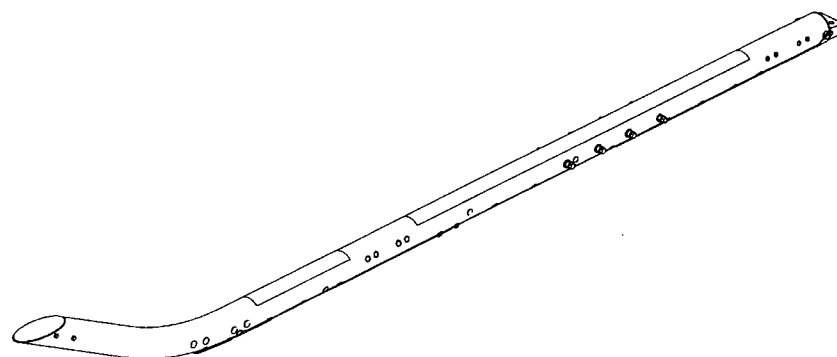
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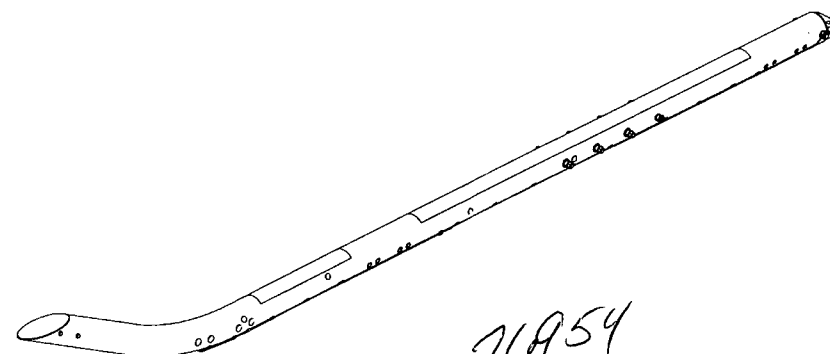
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries





D2750-041 350 SKIDTUBE ASSEMBLY, LH



D2750-042 350 SKIDTUBE ASSEMBLY, RH

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MFG. APPR.	MA	<b>D2750</b>	SHEET 2 OF 11
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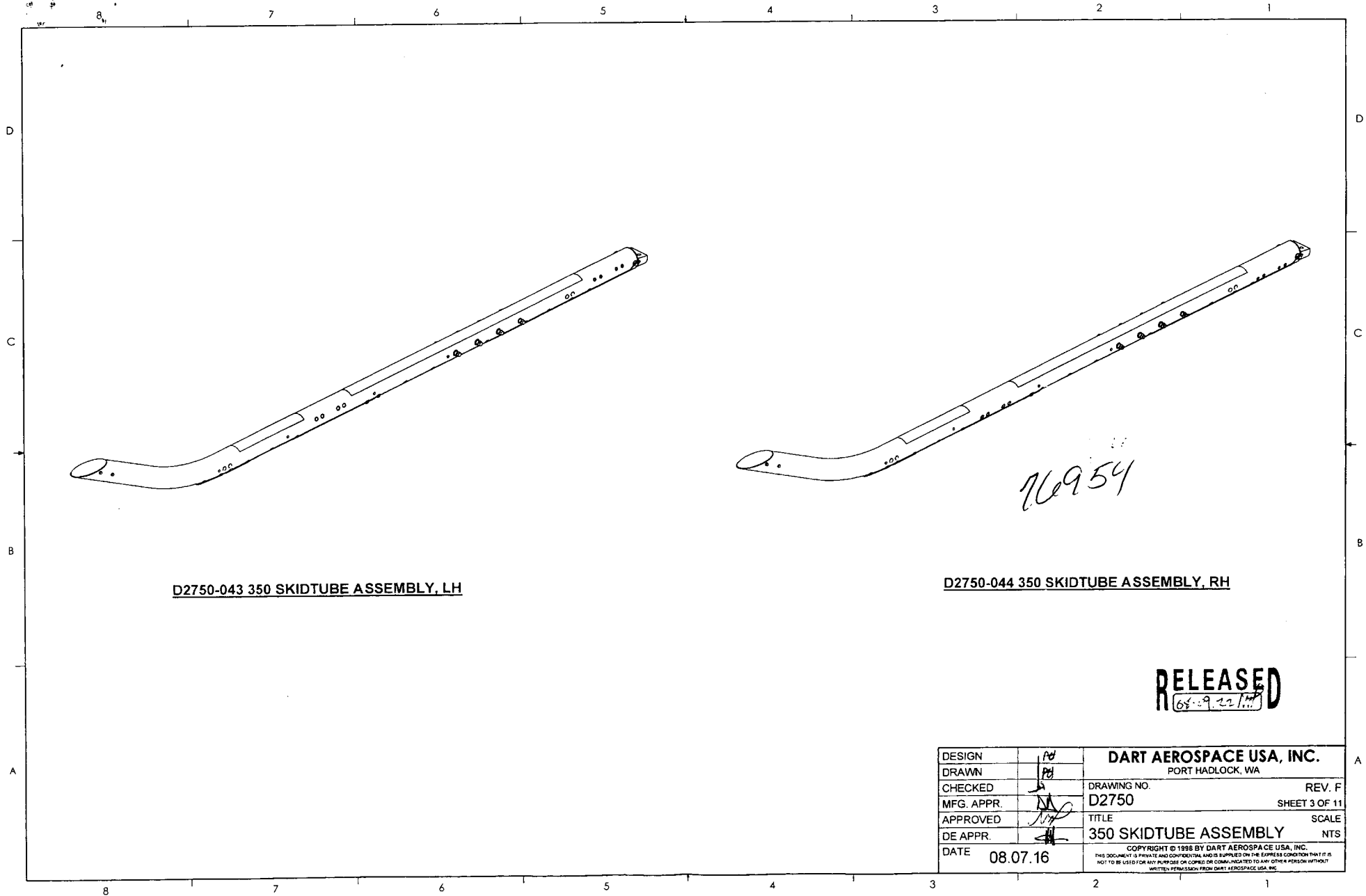
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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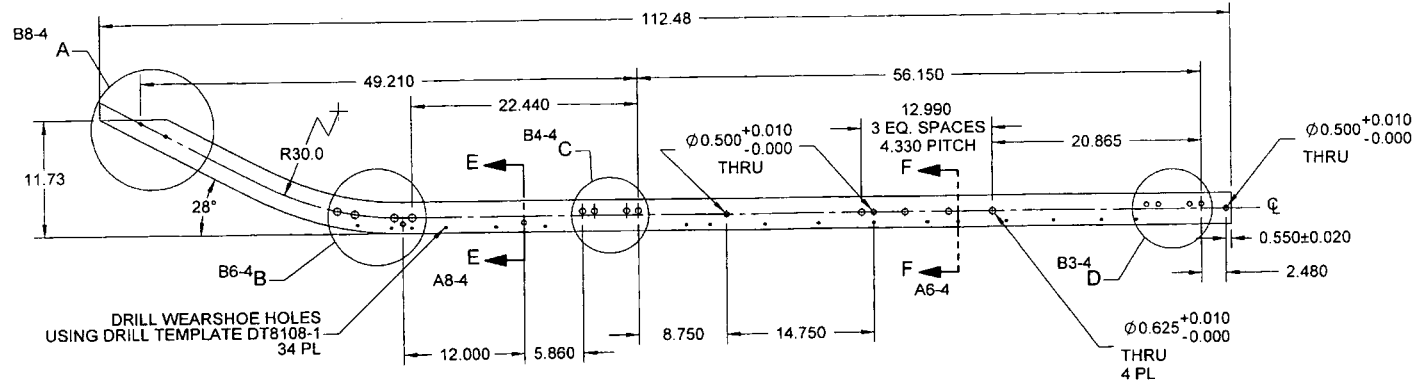
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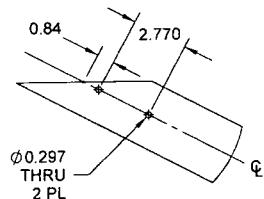
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

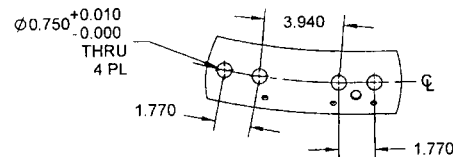
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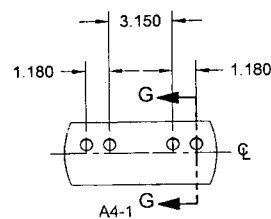
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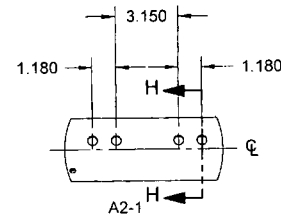
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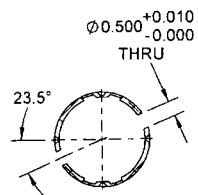
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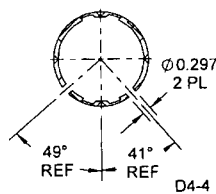
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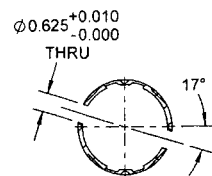
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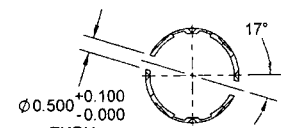
**SECTION E-E**  
SCALE 3X, 2 PL



**SECTION F-F**  
SCALE 3X, 17 PL



**SECTION G-G**  
SCALE 3X, 4 PL



**SECTION H-H**  
SCALE 3X, 4 PL

DESIGN	IPB
DRAWN	IPB
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MFG. APPR.	IPB
APPROVED	IPB
DE APPR.	IPB
DATE	08.07.16

<b>DART AEROSPACE USA, INC.</b> PORT HADLOCK, WA	
DRAWING NO. <b>D2750</b>	REV. F SHEET 4 OF 11
TITLE <b>350 SKIDTUBE ASSEMBLY</b>	SCALE NTS
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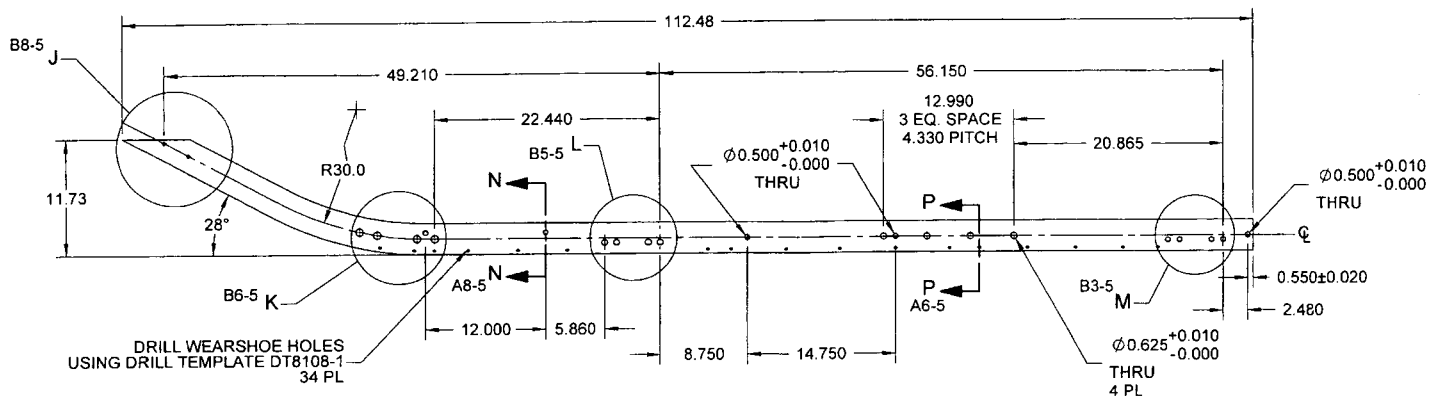
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

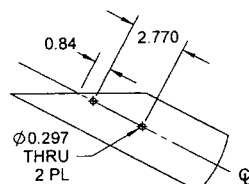
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

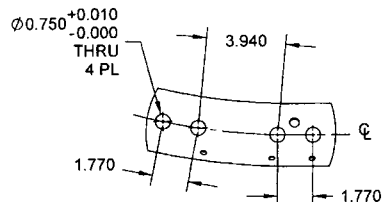
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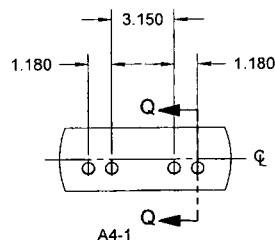
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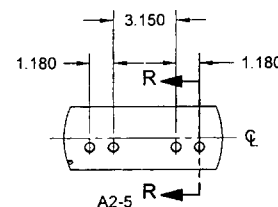
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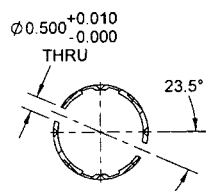
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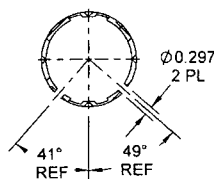
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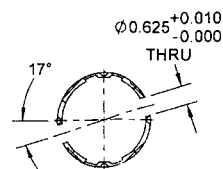
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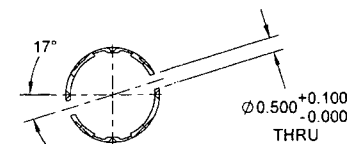
**SECTION N-N**  
SCALE 3X, 2 PL



**SECTION P-P**  
SCALE 3X, 17 PL



**SECTION Q-Q**  
SCALE 3X, 4 PL



**SECTION R-R**  
SCALE 3X, 4 PL

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

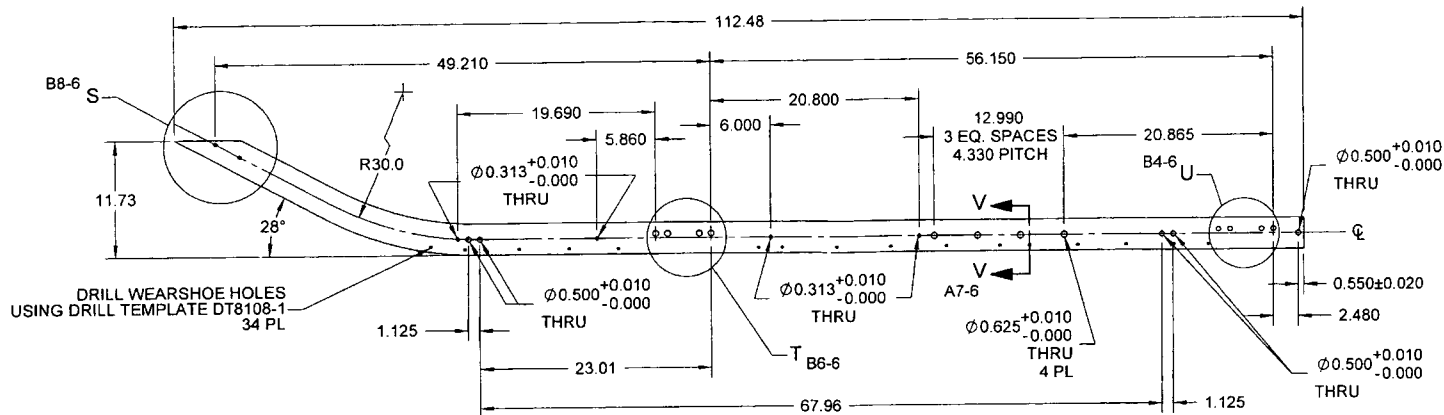
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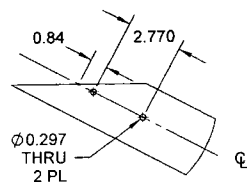
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

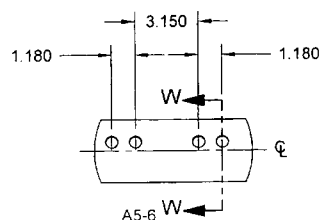




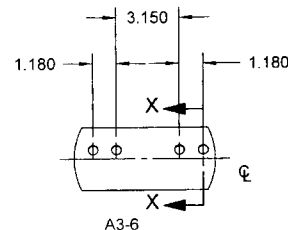
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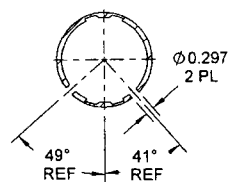
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SCALE 2X



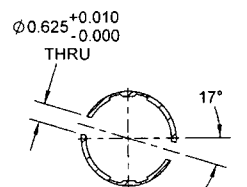
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C5-6  
SCALE 2X



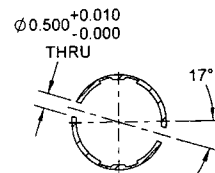
**DETAIL U**  
D3-6  
SCALE 2X



**SECTION V-V**  
C4-6  
SCALE 3X, 17 PL



**SECTION W-W**  
B6-6  
SCALE 3X, 4 PL



**SECTION X-X**  
B4-6  
SCALE 3X, 4 PL

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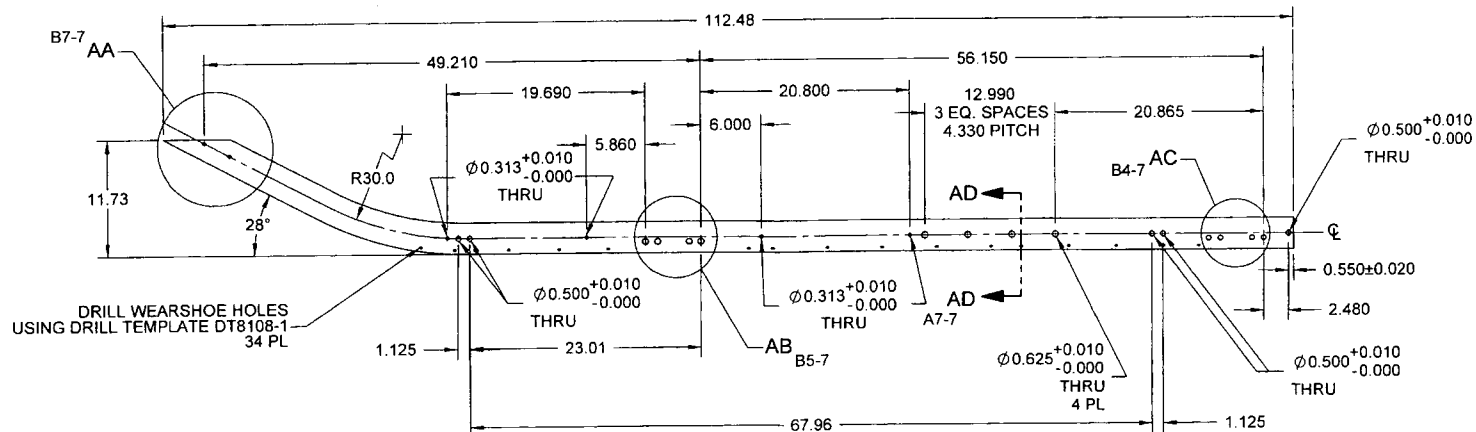
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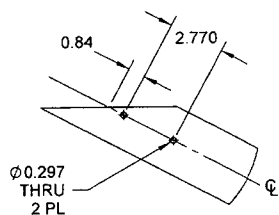
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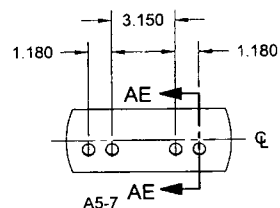
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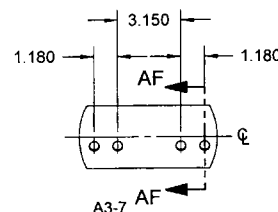
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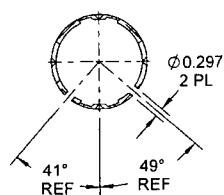
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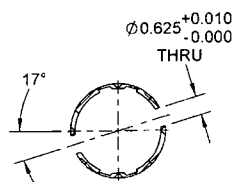
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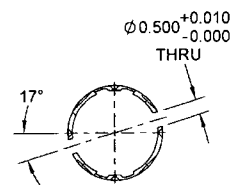
**DETAIL AC**  
SCALE 2X



**SECTION AD-AD**  
SCALE 3X, 17 PL



**SECTION AE-AE**  
SCALE 3X, 4 PL



**SECTION AF-AF**  
SCALE 3X, 4 PL

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MFG. APPR.			SHEET 7 OF 11
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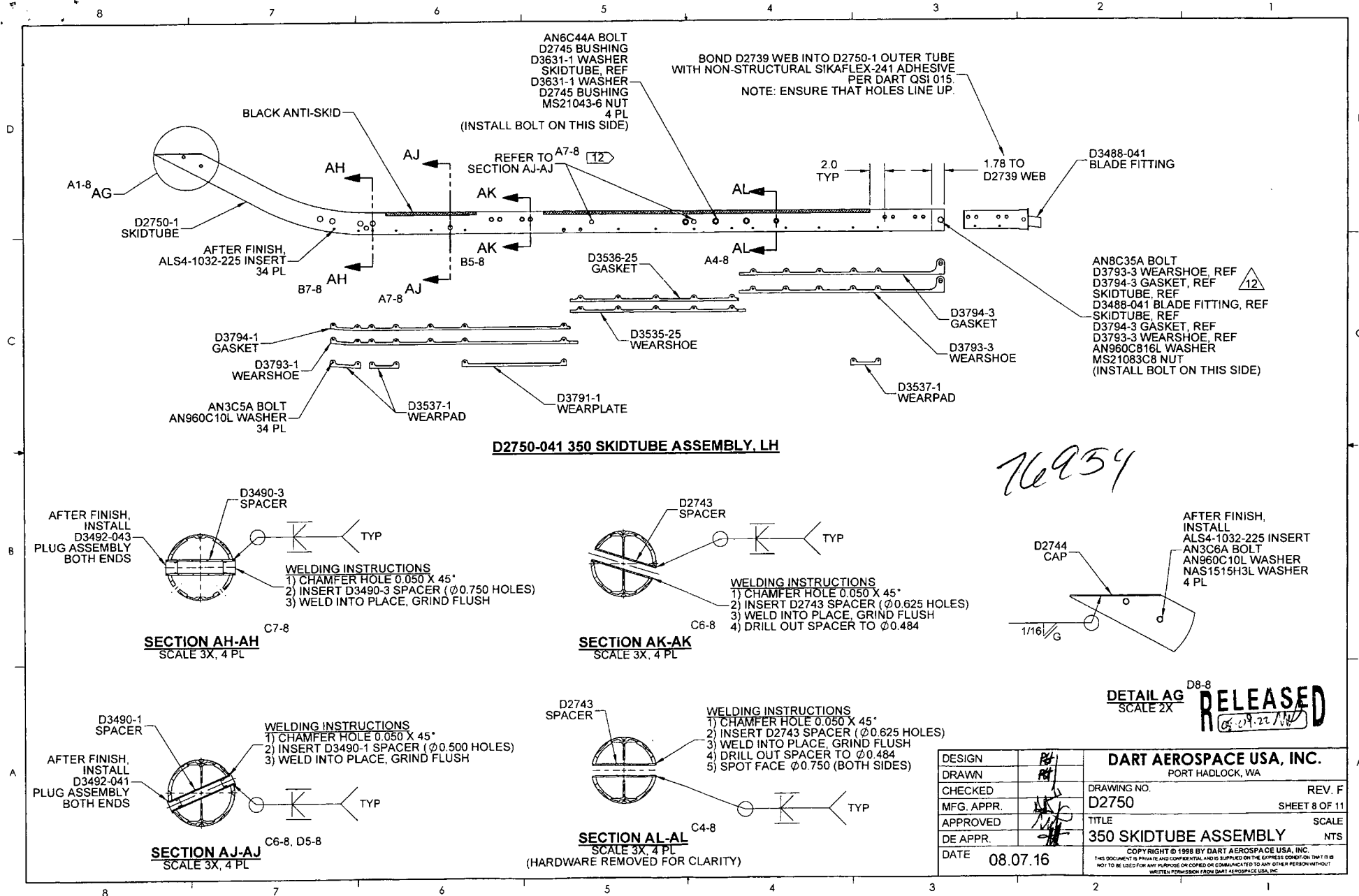
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**NOTE:** Date & initial all entries



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

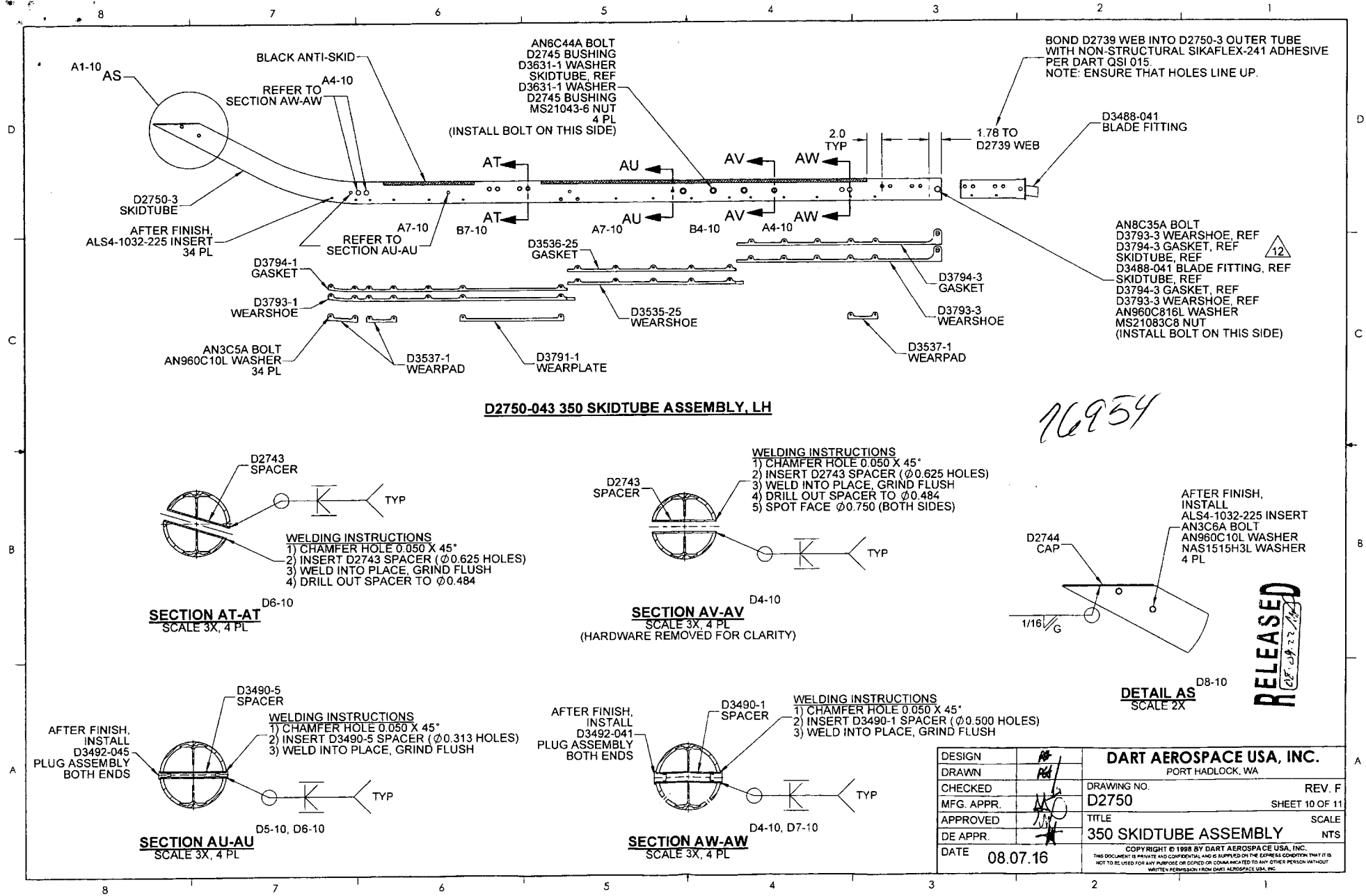
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

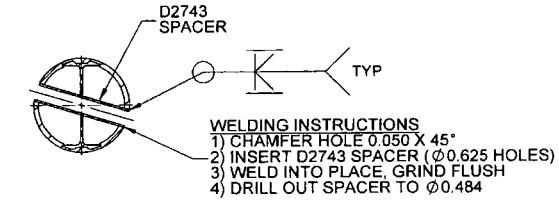
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

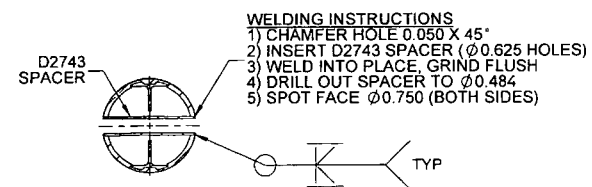




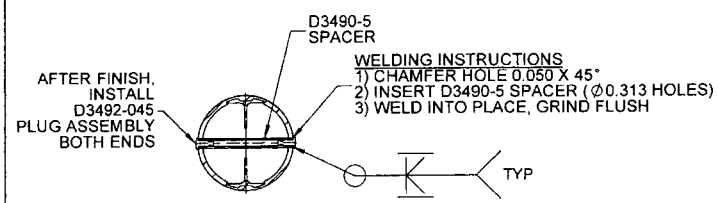
**D2750-043 350 SKIDTUBE ASSEMBLY, LH**



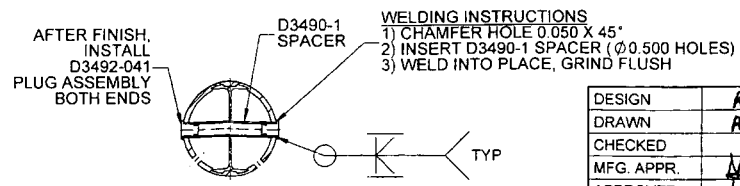
**SECTION AT-AT**  
SCALE 3X, 4 PL



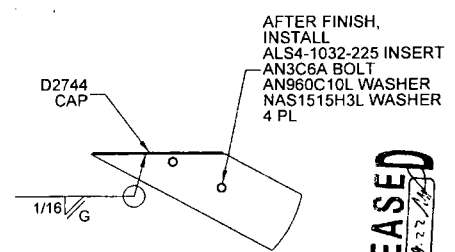
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SCALE 3X, 4 PL  
(HARDWARE REMOVED FOR CLARITY)



**SECTION AU-AU**  
SCALE 3X, 4 PL



**SECTION AW-AW**  
SCALE 3X, 4 PL



**DETAIL AS**  
SCALE 2X

DESIGN	76954	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	76954	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		<b>D2750</b>	SHEET 10 OF 11
APPROVED		TITLE	SCALE
DE APPR.		<b>350 SKIDTUBE ASSEMBLY</b>	NTS
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2008-09-22/14

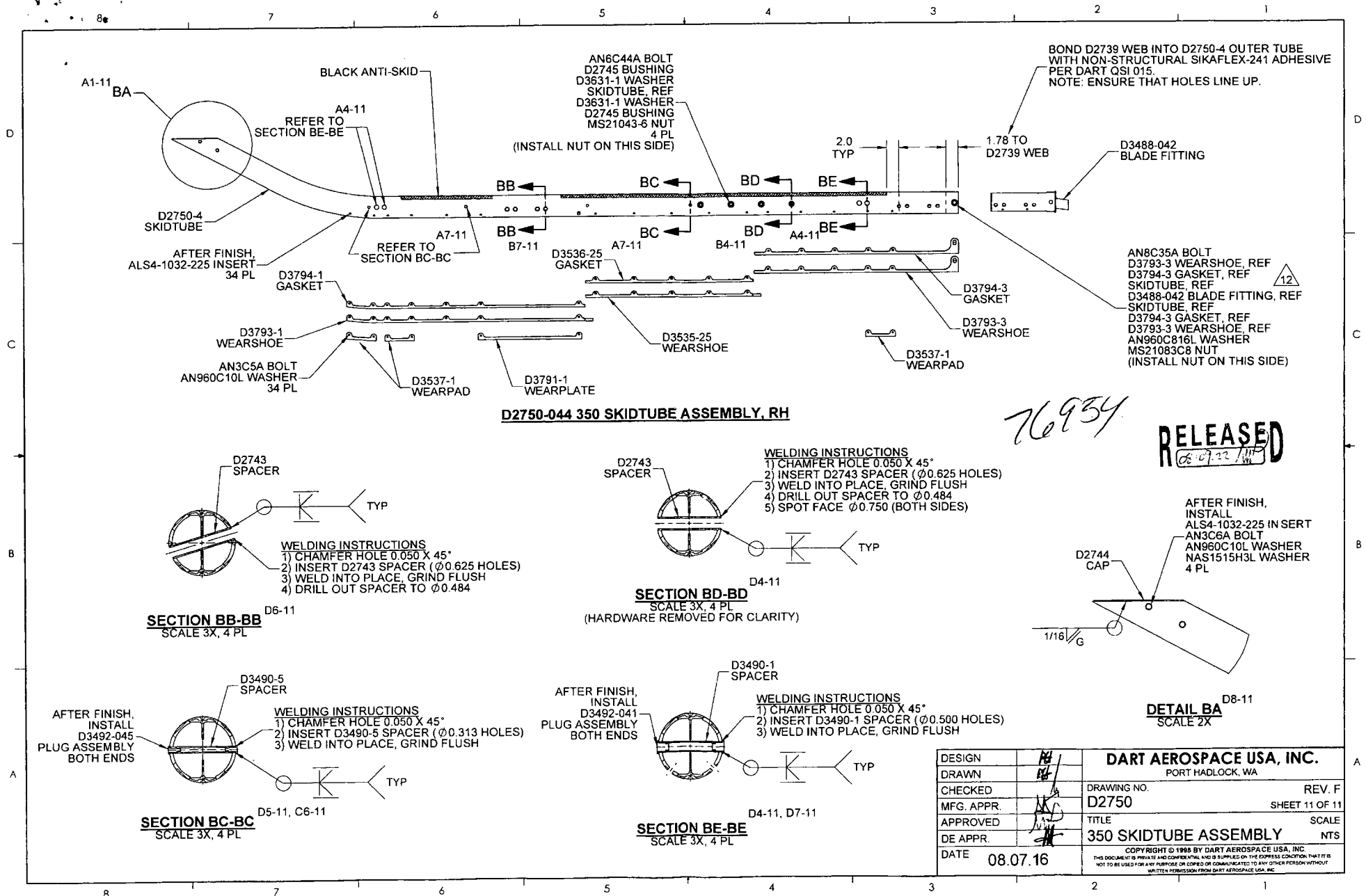
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

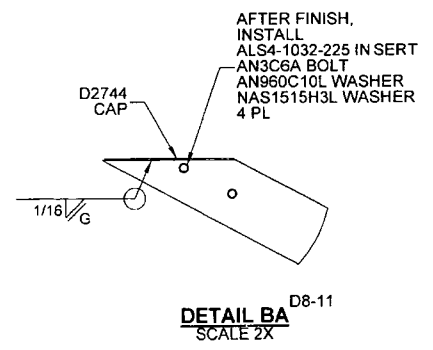
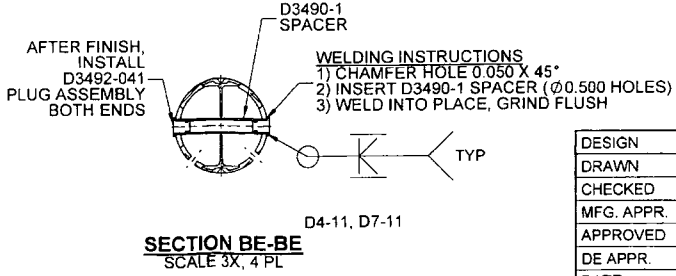
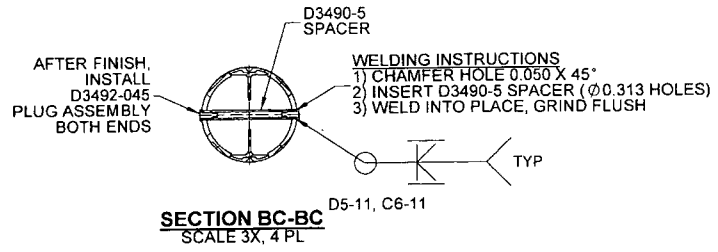
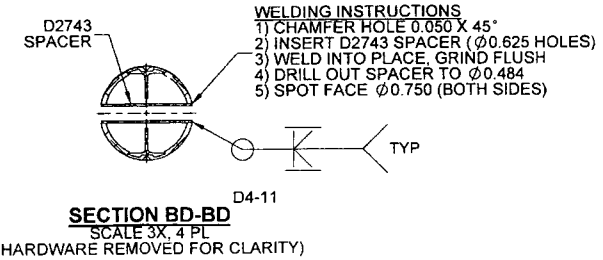
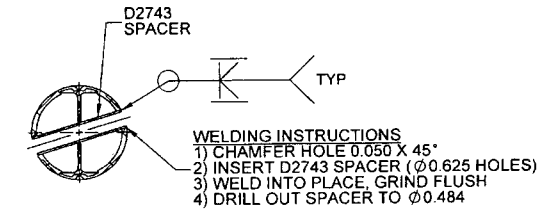
**NOTE:** Date & initial all entries



**D2750-044 350 SKIDTUBE ASSEMBLY, RH**

76934

**RELEASED**  
68-07-22



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DRAWN		PORT HADLOCK, WA	
CHECKED		DRAWING NO. <b>D2750</b>	REV. F
MFG. APPR.			SHEET 11 OF 11
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DE APPR.		<b>350 SKIDTUBE ASSEMBLY</b>	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

NO. 276

AWS D17.1.2001  
QUALIFICATION TEST RECORD

Name: Barclay Elliot  
Job number: 75349  
Part number: 350-636-011  
Description: Skid tube  
Welding Process: Tig[☒] Mig[ ]  
Base material: Alum  
Current: AC[☒] DC[ ]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[ ]  
Penetration: pass[☒] fail[ ]

UNACCEPTABLE

Cracks: pass[☒] fail[ ]  
Undercut: pass[☒] fail[ ]  
Pin holes: pass[☒] fail[ ]  
Overlap (cold lap): pass[☒] fail[ ]  
Porosity (surface): pass[☒] fail[ ]  
Coloration: pass[☒] fail[ ]

Qualifier David Paul Date of Test Coupon 11.11.22

Welder Barclay Elliot Date of Test Coupon 11.11.22

The above named individual is qualified in accordance with AWS D17.1.2001 to weld